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D4931-3
Job Sheet 183215



Part No: D4931-3

Job Qty: 5 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Machining-3		DC
100	Doosan	5 pcs	9/21/18	9/21/18	0.52	4.95	Doosan		DC
110	QC	5 pcs	9/21/18	9/21/18	0.00	0.00	QC2 Machining-3		DC
112	Mill Conv	5 pcs	9/21/18	9/21/18	0.00	1.91	Mill Conv 1		Be
115	QC	5 pcs	9/21/18	9/21/18	0.00	0.00	QC2 Machining-3		18/9/24
120	QC	5 pcs	9/21/18	9/21/18	0.00	0.00	QC8 Machining-3		18/09/25
130	Packaging	5 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3-2	57727	6
140	QC21-SA	5 Ea	9/21/18	9/21/18	0.00	0.00	QC21		9-89

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

DAS
21
9-89

SEP 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.7500 ft (.15 ea)	90-Start up Operation	50/80/10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	33	0

Part Specifications

Specifications could not be found.

Plex 9/13/18 3:14 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 183215
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.058"				
M.O.W.	Maj: 1.0995 Min: 1.0938	1.0965"				
0.13 x 45°	+/-0.030 x +/-0.5°	1/8 45°				
Ø0.063	+0.004/-0.001	.062				
0.08	+/-0.030	.081				
0.906	+/-0.010	.909				
0.13	+/-0.030	.127				
0.25	+/-0.030	.255				
0.938	+/-0.010	.9365				
1.927	+/-0.010	1.933				
0.250	+/-0.010	.254				
0.424	+/-0.010	.429				
0.315	+/-0.010	.316				
0.185	+/-0.010	.186				
37°	+/-0.5°	36.5°				
0.33	+/-0.030	.34				
34°	+/-0.5°	33.5°				
0.532	+/-0.010	.528				
1.063	+/-0.010	1.061				
0.594	+/-0.010	.594	✓			SUOS
0.791	+/-0.010	.788	✓			SUOS
1.188	+/-0.010	1.189				
1.582	+/-0.010	1.583				
0.238	+0.005 -0.001					

Measured by: D.A./D	Audited by:	Preliminary Approval:
Date: 18/19/Sept.	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	



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Container No: S111658



Part: D4931-3

Job No: 183215

Serial No/Batch: S111658

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/20/18